

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009060**Date Inspected:** 26-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yu Min, Chen Ying Xin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

**OBG Trial Assembly Area**

This QA Inspector proceeded to the OBG trial assembly area in response to a verbal request by ABF Representative Mike Williams, who informed this QA Inspector that a Caltrans representative had requested the area cleaned to permit MT inspection of the following:

This QA Inspector performed random VT and MT of approximately 3 meters in length of the deck panel diaphragm to upper floor beam weld on the east side of panel point 20 in segment 3AE. This QA Inspector generated an MT report for this date.

This QA Inspector also randomly observed the following work in progress in the trial assembly area:

5BE/5CE joint – FCAW welding of the bottom plate joint. Welder was identified as 053742. ZPMC QC was identified as CWI Xu Yu Min (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2231-T.

4AW, panel points 24 east and 27 west, upper floor beam flange to web weld, adjacent to deck panel diaphragm weld – ABF performing MT.

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1AW/1BW – bottom plate and side plate joint exterior – sandblasting.

3AE/3BE interior – touch-up painting using brushes.

Bay 10

This QA Inspector also randomly observed the following work in progress in Bay 10:

FCAW welding of weld joint SSTL-1B/K-85B located on south tower, lift 3, skins D to E. Welder was identified as 050041. ZPMC QC was identified as CWI Chen Ying Xin (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2232-C-U2-F. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Li Nan.

SMAW welding of weld joint SSTL3-1I/K-106 and SSTL3-1G/K-96 located inside south tower, lift 3. Welder was identified as 040491. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Wang Hao, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-345-SMAW-2G(2F)-repair. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Li Nan.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations on this date except as noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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